

Date: Monday, 5/15/2006 10:42:41 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FOLDING STEP WELDMENT RH
 Job Number : 27087
 Estimate Number : 10697
 P.O. Number : NIA Part Number : D3388042
 This Issue : 5/15/2006 S.O. No. : NIA Drawing Number : D3388 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : LARGE FAB ASSY Drawing Revision : A
 Previous Run : 26653 Material : NIA
 Due Date : 5/30/2006 Qty: 5 Um: Each
 Written By : *See Comment Below*
 Checked & Approved By : *Ob. 05.15 W*
 Comment : Est. B 05.06.10 Added Step 11 KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D2622120C

Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

D2622-120C extrusion

Batch: *324563*
PE 06.05.24 5

2.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1


 Comment: LARGE FABRICATION RESOURCE 1
 CUT D2622-120C extrusion 85.15" long as per Dwg D3388

PE 06.05.24 5

Deburr and bevel ends for welding

PE 06.05.24 5

3.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>324402</i>

PE 06.05.24 5

4.0

D33872

Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
2	D3387-2	Arm	<i>325934 = 2 326671 = 2 327143 = 6</i>

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 10:42:42 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT RH

Job Number: 27087

Part Number: D3388042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and (1) end cap as per Dwg D3388.

Grind end cap welds flush

Dwg Rev: A

A/R AL ROD Batch: m19123 m15689

PE 06.05.25
FF 06.05.29

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06.05.30 (5)

PD 06.05.29

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06.05.30

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld last end cap as per Dwg D3388.

Inspect for foreign objects as per QSI 024.

Grind end cap welds flush

Dwg Rev: A

A/R AL ROD Batch: m15689

06.06.01 FF

PE 06.05.31

PE 06.05.31

PE 06.05.31

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06.06.02

06.06.03 (5)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

FF 06.06.06

11.0

POWDER COATING

POWDER COATING



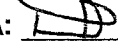
Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

PL 06.06.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/28

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 10:42:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT RH

Job Number: 27087

Part Number: D3388042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

FL 06 06 26 (5)

13.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

11/ 06 06 27 (5)

14.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Spacer

Pick:

Qty Part Number Description Batch

1 D2808 Spacer

B 26 648

Press spacer into D3387-2 arm as per Dwg D3387

SB 06/06/28 (5)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/06/28 (5)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CA

SB 06/06/28 (5)

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/28 (5)

Job Completion



U 06-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

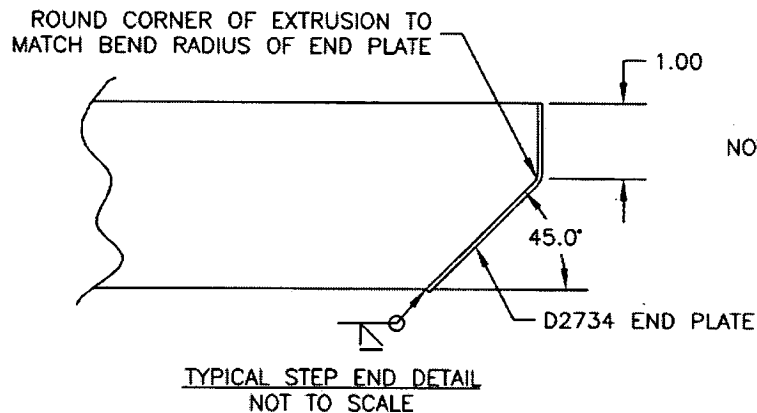
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

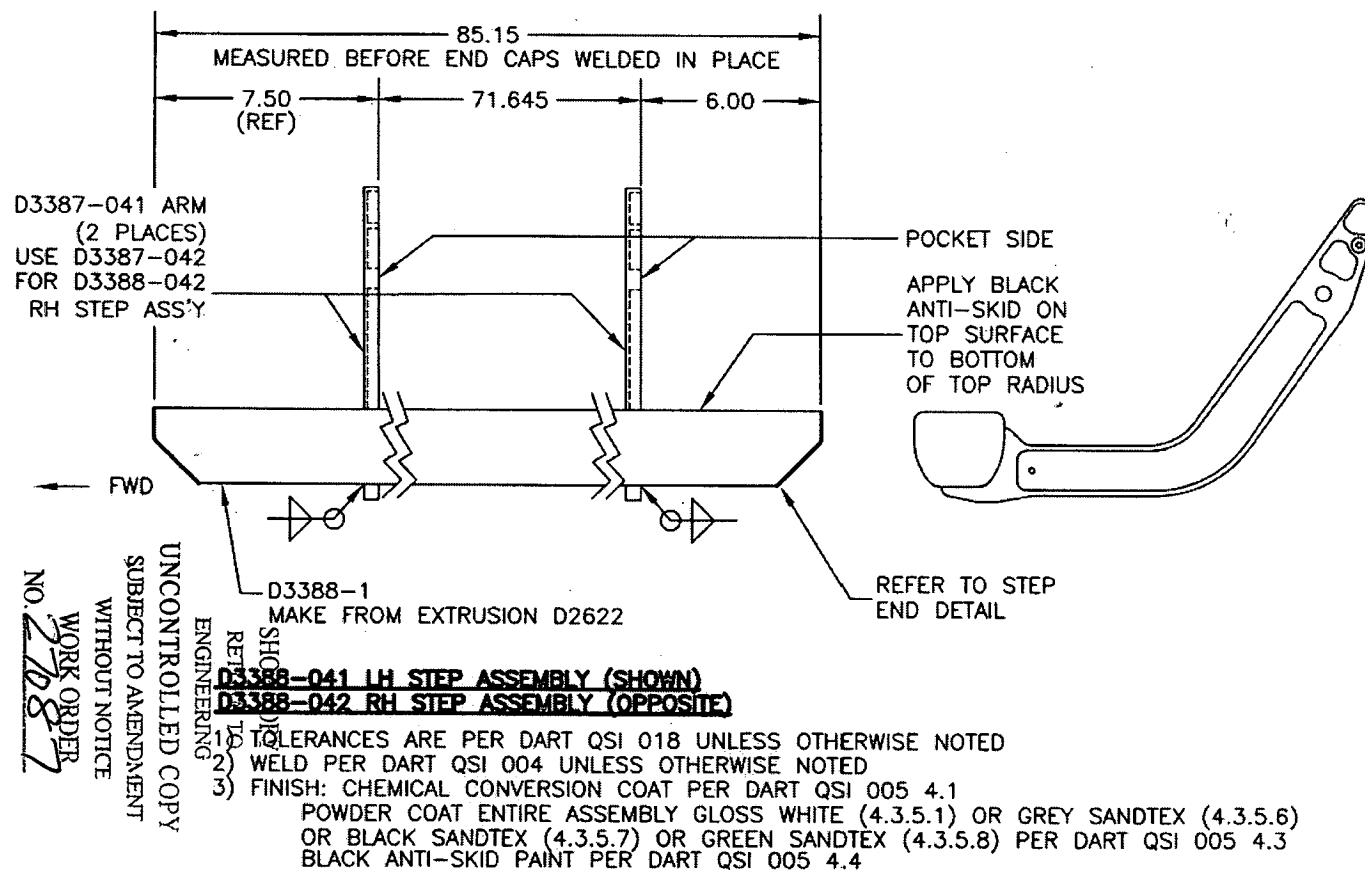
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

RELEASED
05-03-11



NOTE: ALL WELDS SHALL BE 100%
VISUALLY INSPECTED BY A
QUALIFIED INSPECTOR PER
DART QSI 004



DESIGN		APPROVED	DRAWING NO.	REV. A
CP		CP	D3388	SHEET 1 OF 1
CHECKED		APPROVED	DATE	
H		H	05.01.20	
DATE		TITLE		
05.01.20		STEP WELDMENT		
A	05.01.20	NEW ISSUE		
		SCALE		
		NTS		

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